

WHAT IS CLAIMED IS:

1. A fastener arrangement for use in manufacturing recloseable bags comprising:

a first fastener;

5 a second fastener connected to said first fastener, each of said fasteners comprising a male track with a male profile and a female track with a female profile, said male and female profiles being releasably engageable to each other; and

10 a slider slidably mounted to each of said fasteners for movement between a closed position and an open position, said male and female profiles being engaged to each other while said slider is in said closed position, said male and female profiles being disengaged from each other in response to movement of said slider from said closed position to said open position.

15 2. The fastener arrangement of claim 1 wherein said first fastener is connected in line with said second fastener to form a continuous male track and a continuous female track.

20 3. The fastener arrangement of claim 1 wherein said first fastener is releasably connected in line with said second fastener to form a continuous male track and a continuous female track.

4. The fastener arrangement of claim 1 wherein each of said fasteners further comprises a first fin extending downward from said male profile and a second fin extending downward from said female profile, said first fastener connected in line with said second fastener to form a continuous first fin and a continuous second fin.

25 5. The fastener arrangement of claim 4 wherein said continuous first fin and said continuous second fin are joined to each other along a one-time breakable preferential area of weakness.

6. The fastener arrangement of claim 2 wherein said first and said second fasteners are wrapped about a roll.

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7. The fastener arrangement of claim 1 wherein said first fastener and said second fastener each have a length approximately equal to a width of said recloseable bag.

8. The fastener arrangement of claim 1 wherein said first fastener is
5 releasably adhered to said second fastener, said male and female tracks of said first fastener being substantially parallel to said male and female tracks of said second fastener.

9. The fastener arrangement of claim 8 wherein said first fastener and said second fastener are rolled into a cylinder having a longitudinal axis, said male and
10 female tracks of said first and said second fasteners being substantially parallel to said longitudinal axis.

10. The fastener arrangement of claim 8 wherein said first fastener is releasably adhered to said second fastener by a releasable adhesive.

11. The fastener arrangement of claim 8 wherein said first fastener is
15 releasably adhered to said second fastener by a releasable seal.

12. The fastener arrangement of claim 1 wherein each of said fasteners further comprise a first fin extending downward from said male profile and a second fin extending downward from said female profile, one of said fins of said first fastener being releasably adhered to one of said profiles of said second fastener.

20 13. The fastener arrangement of claim 12 wherein said first fin and said second fin are joined to each other along a one-time breakable preferential area of weakness.

14. A sheet of zippers for use in manufacturing recloseable packages, said sheet of zippers comprising:
25 a first zipper comprising a first male track with a first male profile and a first female track with a first female profile, said first male and first female profiles being releasably engageable to each other;
a first slider slidably mounted to said first zipper for movement between a closed position and an open position, said first male and first female profiles being

engaged to each other while said first slider is in said closed position, said first male and first female profiles being disengaged from each other in response to movement of said first slider from said closed position to said open position;
a second zipper comprising a second male track with a second male profile and a
5 second female track with a second female profile, said second male and second female profiles being releasably engageable to each other; and
a second slider slidably mounted to said second zipper for movement between a closed position and an open position, said second male and second female profiles being engaged to each other while said second slider is in said closed position, said second
10 male and second female profiles being disengaged from each other in response to movement of said second slider from said closed position to said open position, said second zipper being releasably connected to said first zipper.

15. The sheet of claim 14 wherein said first zipper and said second zipper each have a length approximately equal to a width of said recloseable package.

16. The sheet of claim 14 wherein said first zipper is releasably adhered to said second zipper by a releasable adhesive.

17. The sheet of claim 14 wherein said first zipper is releasably adhered to said second zipper by a releasable seal.

18. The sheet of claim 14 wherein said first male and female tracks of said
20 first zipper are substantially parallel to said second male and female tracks of said second zipper.

19. The sheet of claim 14 wherein each of said zippers further comprises a first fin extending downward from said male profile and a second fin extending downward from said female profile, one of said fins of said first zipper being releasably
25 adhered to one of said profiles of said second zipper.

20. The sheet of claim 18 wherein said sheet is wrapped about a roll having a longitudinal axis, said first and said second male and female tracks are substantially parallel to said longitudinal axis.

21. The sheet of claim 14 second fastener are rolled into a cylinder having a longitudinal axis, said male and female tracks of said first and said second zippers are substantially parallel to said longitudinal axis.

22. A zipper arrangement for use in manufacturing recloseable bags, said
5 zipper arrangement comprising:

a male track with a male profile;

a female track with a female profile, said male and female profiles being
releasably engageable to each other; and

a plurality of sliders slidably mounted to said engageable male and female tracks for
10 movement between a closed position and an open position, said male and female
profiles being engaged to each other while said slider is in said closed position, said
male and female profiles being disengaged from each other in response to movement of
said slider from said closed position to said open position.

23. The zipper arrangement of claim 22 wherein a first slider is positioned a
15 distance approximately equal to a width of one of said recloseable bags away from a
second slider.

24. The zipper arrangement of claim 22 wherein one of said sliders is
positioned in a length of said male and female track corresponding to a width of one of
said recloseable bags.

20 25. The zipper arrangement of claim 22 wherein said zipper arrangement is
wrapped around a roll.

26. The zipper arrangement of claim 22 wherein one of said sliders is
positioned in a length of said male and female track corresponding to a width of one of
said recloseable bags such that when wrapped in a roll said zipper arrangement
25 occupies a minimal amount of space by preventing adjacent layers of zipper
arrangement on said roll from stacking sliders on top of each other.

27. A method of manufacturing recloseable packages, said method
comprising:
providing a first wall panel opposing a second wall panel;

positioning a zipper between said first and second wall panels, said zipper including a first track with a first profile and a second track with a second profile, said first and second profiles being releasably engageable to each other, and a slider slidably mounted to said zipper for movement between a closed position and an open position, said first and second profiles being engaged to each other while said slider is in said closed position, said first and second profiles being disengaged from each other in response to movement of said slider from said closed position to said open position;

adhering said first profile of said zipper to said first wall panel;

forming first and second spaced side seals in said web to define first and second sidewalls of said package;

adhering said second profile of said zipper to said second wall panel; and

cutting said web along said side seals to separate adjacent packages.

28. The method of claim 27 further including a step of feeding a zipper arrangement between said first and second wall panels before positioning said zipper, said zipper arrangement comprising a plurality of said zippers connected in line with each other.

29. The method of claim 27 further including a step of feeding a zipper sheet of said zippers to between said first and second wall panels before positioning said zipper, said sheet of zippers comprising a plurality of said zippers releasably adhered to each other.

30. The method of claim 27 wherein said zipper is positioned and said first profile of said zipper is adhered to said first wall panel before providing said first and second wall panels.

31. The method of claim 27 further including a step of filling said package with a product through a mouth of said web after forming said first and second side seals.

32. The method of claim 27 wherein said first and second wall panels are provided by folding a web of material.

7 ~~33.~~ The method of claim ~~27~~² wherein said zipper is positioned at a mouth of said first and second wall panels.

sub a4 5 ~~34.~~ The method of claim ~~33~~ further including a step of filling said package with a product through said mouth before adhering said second profile to said second wall panel.

a ~~35.~~ The method of claim ~~27~~¹ wherein said zipper is positioned below and adjacent a mouth of said first and second wall panels.

sub a5 10 ~~36.~~ The method of claim ~~35~~ further including a step of filling said package with a product through said mouth before adhering said second profile to said second wall panel.

11 ~~37.~~ The method of claim ~~27~~ wherein said zipper is positioned at a bottom of said first and second wall panels.

sub a6 15 ~~38.~~ The method of claim ~~37~~ further including a step of filling said package with a product through said mouth after adhering said first profile to said first wall panel and after adhering said second profile to said second wall panel.

13 ~~39.~~ The method of claim ~~31~~⁵ wherein said side seals are cut before filling said package with said product.

14 ~~40.~~ The method of claim ~~31~~⁵ wherein said side seals are cut after filling said package with said product.

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